

October-19-11 1:35:24 PM

75250

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

24 18

Cust Item ID:

Start Date: 19/10/2011 **Start Qty:** 24.00

Required Date: 07/11/2011 **Req'd Qty:** 24.00

~~*24*~~

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date: 11/10/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

[illegible]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75250

75250

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Item ID: D2858-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Hinge Bracket
 Start Date: 19/10/2011 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 07/11/2011 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts- second check Memo	0.00 0.00		11-11-1		18			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				18	BR	11-11-1	
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							

START TIME: 11:30 OVEN TEMPERATURE:
 FINISH TIME: 12:00

M 118439 3200F

18 ✓ M-L 11/11/03

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 75250

75250

Parent Item: D2858-1

D2858-1

Parent Item Name: Hinge Bracket

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			100	f	9.1020	0.163	4.117895			

M6061T6B1 500X01 250

6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT004

9.102

118071

0.112

118400

8.99

4.118

F.K. 11/10/30

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DART AEROSPACE LTD		Work Order:	75250
Description: Hinge Bracket		Part Number:	D2858-1
Inspection Dwg: D2858 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	.175			3UM 06	
Ø0.400	+0.006/-0.001	.400			"	
R0.125	+/-0.010	.125			"	
0.328	+/-0.010	.328			"	
0.820	+/-0.005	.820			"	
1.476	+/-0.010	1.476			"	
0.342	+/-0.010	.342			"	
0.875	+/-0.005	.875			"	
1.56	+/-0.030	1.563			"	
0.147	+/-0.010	.151			"	
0.717	+/-0.010	.719			"	
0.697	+/-0.010	.698			"	
0.229	+/-0.010	.233			"	
R0.125	+/-0.010	.125			"	
R0.063	+/-0.010	.063			"	
0.063	+/-0.010	.063			"	
0.126	+/-0.010	.126			"	
0.630	+/-0.010	.633			"	
R0.354	+/-0.010	.352			"	
0.965	+/-0.010	.968			"	
Ø0.166	+0.005/-0.001	.170			"	
R0.125	+/-0.010	.125			"	
32.7°	+/-0.5°	32.7			SD 02	

Measured by: <i>BC / SA</i>	Audited by: <i>RP</i>	Prototype Approval:	N/A
Date: <i>11/10/12</i>	Date: <i>11/10/12</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.30	New Issue	KJ/EC/DD <i>AK</i>	<i>DD</i>

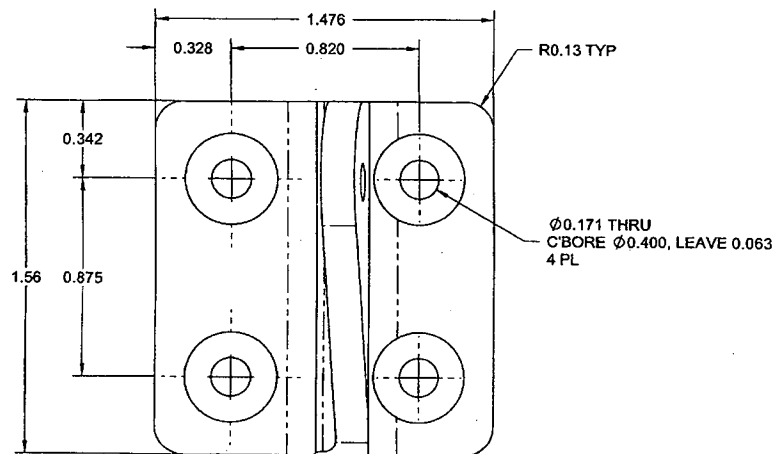
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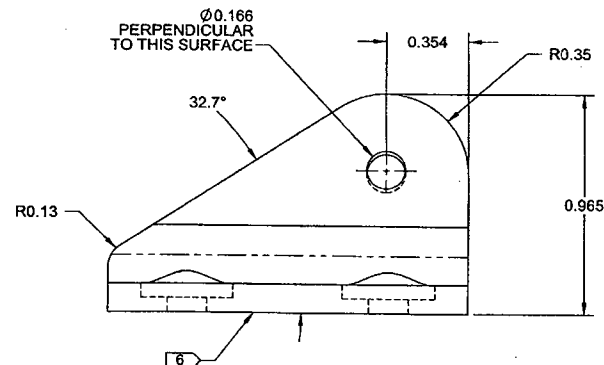
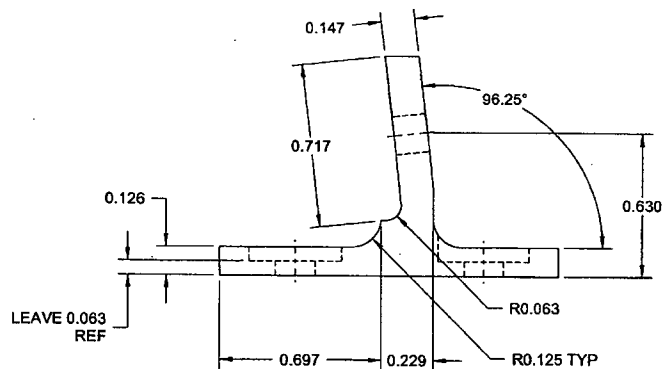
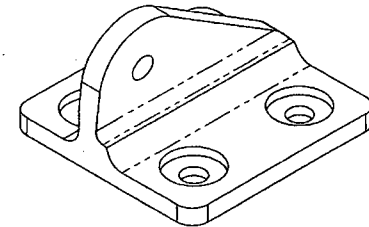
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 75250 M.L.J

11/10/19



RELEASED
2010-11-26

D2858-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	KE	DART AEROSPACE LTD	REV. C
DRAWN	KE	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 2
CHECKED	KE	D2858	SCALE
MFG. APPR.	KE	HINGE BRACKET	NTS
APPROVED	KE		
DE APPR.	KE		
DATE	10.10.12		

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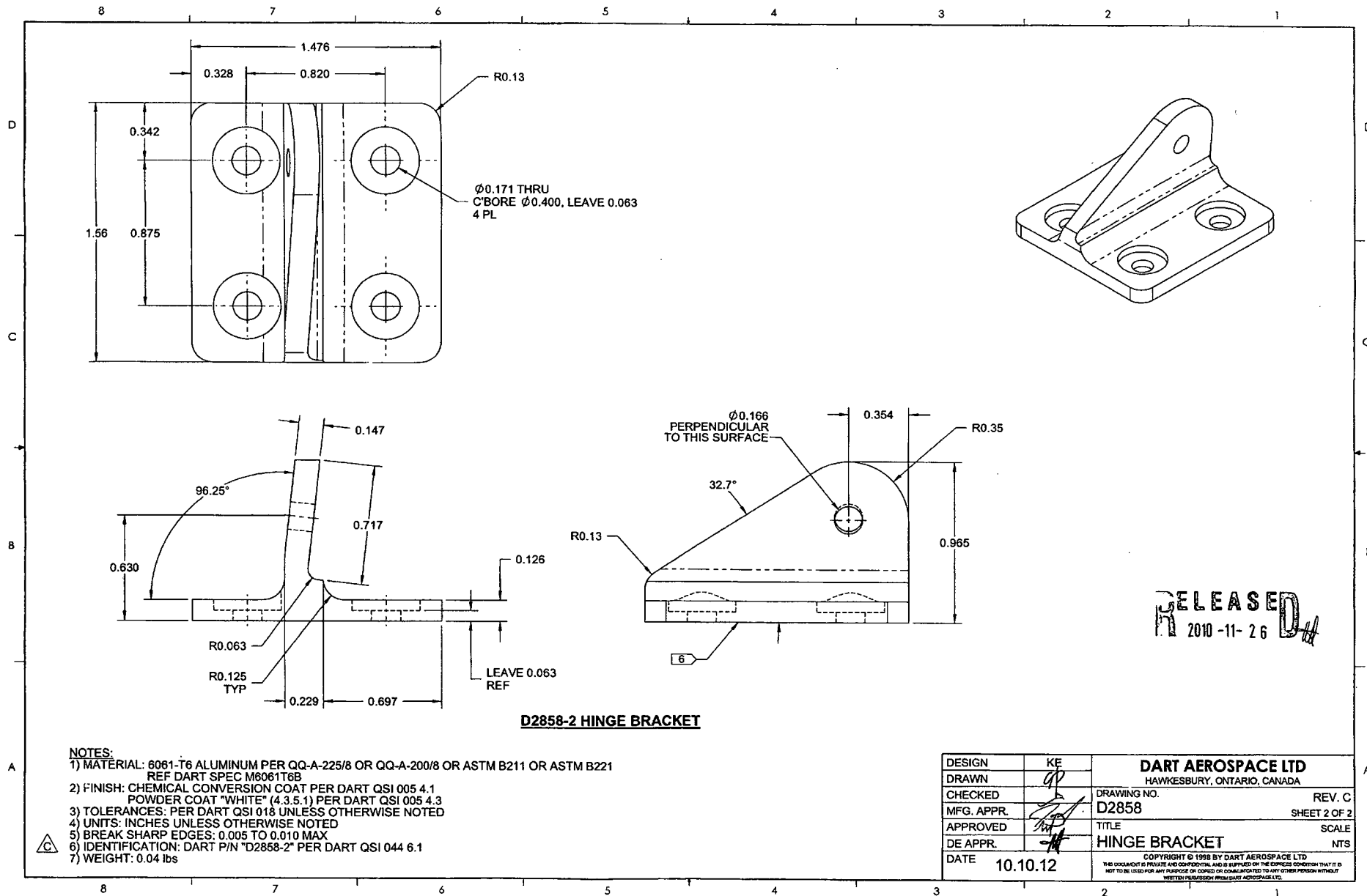
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